TAFT•PEIRCE **ENGINEERING DATA**

PRODUCTION/INSPECTION TOOL DIV.
BULLETIN NO. 9205-S
JUNE 1, 1971

NEW MODEL 9205-S INTERMEDIATE BENCH CENTER

This new Intermediate Bench Center is designed to bridge the capacity gap between the Taft-Peirce Model 9205-M Instrument Bench Center and the standard No. 9205 8″ swing models.

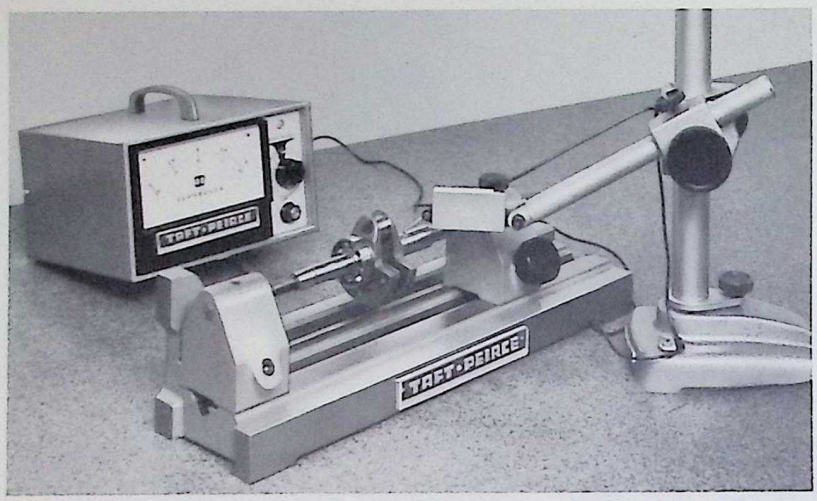
The Style 9205-S may be used in either a horizontal or a vertical position as a means of rapidly and precisely inspecting small and medium sized parts machined on centers.

An unusual feature of this new bench center is the center point in the headstock. It may be rotated within ±.0015″ eccentric range of adjustment to bring the work piece centers perfectly parallel to the bed or

surface plate on which the bench center is placed. This permits an extremely accurate reading of parallelism and concentricity in a horizontal plane. The entire unit may then be turned on end to check runout and squareness of shoulders or sides of grooves.

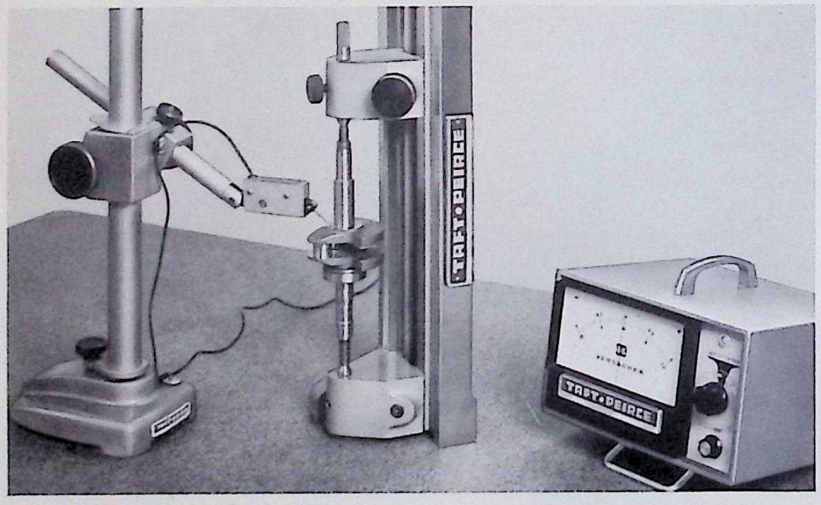
The tailstock assembly is provided with a spring-loaded center which may be securely locked with a knurled knob. Locking of headstock and tailstock in position along the bed is accomplished by means of a knurled knob on the tailstock and an allen-head screw in the headstock.

For necessary balance and stability in the vertical position, the headstock should be located at the extreme left end of the bed and locked in place.



HORIZONTAL POSITION

Checking concentricity of a miniature crankshaft with new 9205-S Intermediate Bench Center and Taft-Peirce Versachek electronic gage.



VERTICAL POSITION

To indicate shoulder runout, the Intermediate Bench Center is placed vertically on its precision-ground end pads. Surface plate is a Taft-Peirce No. 9213.

SPECIFICATIONS

Headstock, tailstock, and base of the new 9205-S Intermediate Bench Center are made of close grained cast iron, thoroughly seasoned and carefully heat treated for maximum stability. Each is machined for precise alignment of the ½″ x 60 hardened and ground tool steel centers.

Swing	5″
Distance between centers	12″
O/A length	17¾″
Width	5″
Weight	26 lbs.
Overall accuracy	Centers parallel to base within .0002″ total indicator reading Centers square with end pads within .0003″ in 6 inches